

Work Order ID 129083

January-28-15 12:33:10 PM

129083

Page 1

Item ID: D2680-041 Accept *N19000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Nut Plate
 Start Date: 1/28/15 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: u Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2680	Rev B1								

100 0.00
 100 FLOW WATER JET 40 0 Jm15-2-10
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2680 Dwg Rev: B1 Prog Rev: B1 2-
 Debur if necessary
 1010.063

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB 40 0 Jm15-2-10
 QC Memo 0.00
 Quality Control

120 0.00
 120 QC8- Inspect parts - second check 40 0
 QC Memo 0.00
 Quality Control

DAS
38
9-89

FEB 10 2015

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1 29083

Item ID: D2680-041

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 1/28/15 **Start Qty:** 20.00 ***20***

Cust Item ID:

Required Date: 2/06/15 **Req'd Qty:** 20.00 ***20***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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1 2908.3

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Nut Plate

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190 Identify as per dwg & Stock Location: KG

0.00

190

Packaging Memo

0.00

Packaging

68-6
90
SVO

45

FEB 21 2015

200 QC21- Final Inspection - Work Order Release

0.00

200

QC Memo

0.00

Quality Control

15/2/23 ~~4~~

ME
15-2-23

Picklist Print

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Page 1

Work Order ID: 129083

129083

Parent Item: D2680-041

D2680-041

Parent Item Name: Nut Plate

Start Date: 1/28/15

Required Date: 2/06/15

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: D04.10.01 Added Steps 2-4, 7-8KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

170

sf

128.0000

0.0131

1

M1010S16GA

1010/1025 sheet 16GA

**

Jm15-2-10

Location

Loc Qty

Loc Code

MAT019

128

124428

128

124428

MS20426AD3-3

Purchased

No

170

Each

695.0000

2

40

MS20426AD3-3

RIVET

**

DAS
28
9-89

FEB 20 2015

Location

Loc Qty

Loc Code

ST313

695

M128754

695

80

MS21069L4

Purchased

No

110

Each

53.0000

1

20

MS21069L4

Nut Plate

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST301

53

120498

2

m128636

51

40 ✓

DART AEROSPACE LTD		Work Order:	129083
Description: Nut Plate		Part Number:	D2680-1
Inspection Dwg: D2680 Rev: B1			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	Jm	Audited by:	9-89	Prototype Approval:	N/A
Date:	15-2-10	Date:	FEB 10 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue P/O D2680-041	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

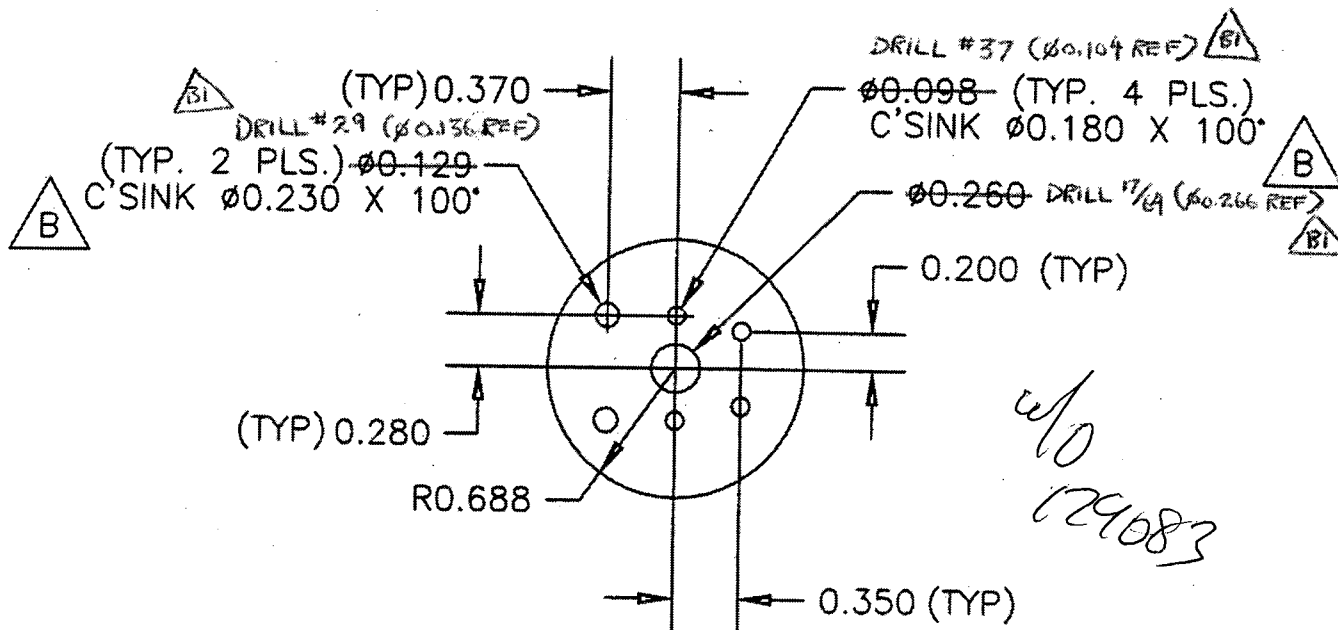
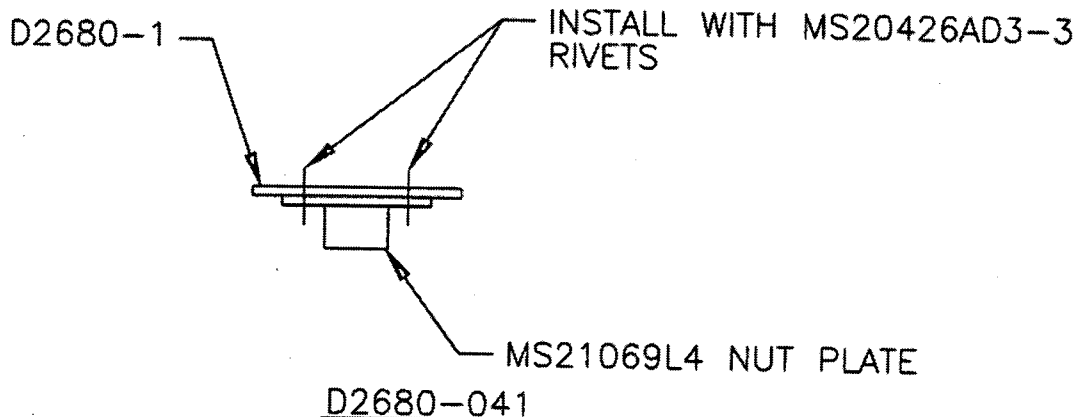
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
BI	<i>CP</i> 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

GAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BI POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
D2680-1

DQA: _____ Date: _____



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